

Date: Thursday, 11/9/2006 4:37:12 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                  |                         |
|-----------------------|--|------------------|-------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : 206 EXTRUSION BENDING |
| Job Number            | : 29388  |                  |                         |
| Estimate Number       | : 10311  |                  |                         |
| P.O. Number           | : N/A  | Part Number      | : D2620                 |
| This Issue            | : 11/9/2006  | S.O. No.         | : JIA                   |
| Prsht Rev.            | : NC   | Drawing Number   | : D2620 REV B           |
| First Issue           | : N/A  | Project Number   | : N/A                   |
| Previous Run          | : 28932  | Drawing Revision | : B                     |
| Written By            | : <i>[Signature]</i>   | Material         | : N/A                   |
| Checked & Approved By | : <i>[Signature]</i>   | Due Date         | : 11/24/2006            |
| Comment               | Qty: 20 Um: Each<br>Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF |                  |                         |

## Additional Product

Job Number:



| Seq. #:  | Machine Or Operation: | Description :                |                                 |
|--|-----------------------|------------------------------|---------------------------------|
| 1.0  | D26001160             | Extrusion Round 3" 206       |                                 |
| <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)<br>Extrusion Round 3" 206  |                       |                              |                                 |
|  | Pick;                 |                              |                                 |
| Qty  | Part Number           | Description                  | Batch                           |
| 1  | D2600-1               | Extrusion Round 3"206        | <i>29388-24508</i> 7-11-13 (41) |
| 2.0  | LANDING GEAR 1        | LANDING GEAR RESOURCE 1      |                                 |
| <b>Comment:</b> LANDING GEAR RESOURCE 1<br>1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 |                       |                              |                                 |
| 2- Cut Fwd end of tube as per Dwg D2620  |                       |                              |                                 |
| 3.0  | QC5                   | INSPECT WORK TO CURRENT STEP |                                 |
| <b>Comment:</b> INSPECT WORK TO CURRENT STEP   |                       |                              |                                 |
| 4.0  | PACKAGING 1           | PACKAGING RESOURCE #1        |                                 |
| <b>Comment:</b> PACKAGING RESOURCE #1<br>Identify and Stock  |                       |                              |                                 |
| Location: <i>LG BE 07/11/15</i> (41)   |                       |                              |                                 |
| 5.0  | QC21                  | FINAL INSPECTION/W/O RELEASE |                                 |
| <b>Comment:</b> FINAL INSPECTION/W/O RELEASE   |                       |                              |                                 |
| Job Completion <i>C07101119</i>  |                       |                              |                                 |

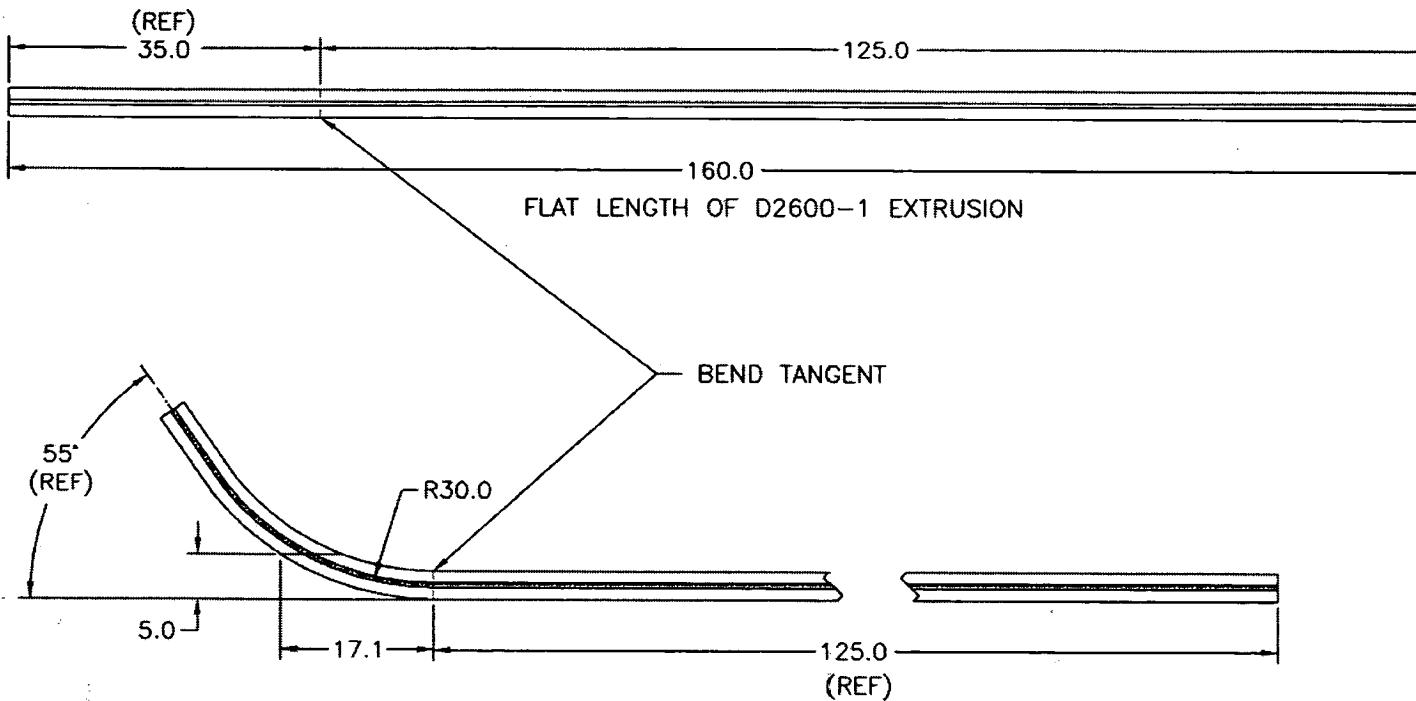
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING  
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.  
GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.  
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
2. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.  
TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND.  
TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.  
TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND.  
TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**DART**

COPY  
GIVEN

|             |          |                                     |
|-------------|----------|-------------------------------------|
| DESIGN      | DRAWN BY | DART AEROSPACE USA, INC.            |
|             | RF       | FAIRCHILD INTERNATIONAL AIRPORT, WA |
| CHECKED     | APPROVED | DRAWING NO.                         |
|             | KC       | D2620                               |
| DATE        |          | TITLE                               |
| 99.09.10    |          | 206 SKIDTUBE BENDING CONTROL        |
| A           | 97.11.07 | NEW ISSUE                           |
| B           | 97.09.10 | UPDATE FOR IN-HOUSE BENDING         |
| RELEASED    |          | REV. B                              |
| 44.04.15 DS |          | SHEET 1 OF 1                        |
|             |          | SCALE 1:20                          |

